

Work Order ID 92682

92682

Page 1

November-07-12 1:53:24 PM

Item ID: D120-638-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 11/06/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: MLS Date: 12-11-08

Tooling:

Date:

Stop ***NR2***

QC: Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

0.00

0.00

JB
DAS
15
12-12-20

2 *for MLS 12-12-20*
(2)
12/12/19
DAS
06
98

160

160

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

2 *12/12/19 JB*

170

170

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

DAS
15
12-12-20

2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
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Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 92682

92682

Page 2

November-07-12 1:53:24 PM

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Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD120-638-011
Location: FG 013

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

06
9-28

(20) 8 12/12/20

12/11/10

mf
12-12-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

November-07-12 1:53:23 PM

Page 1

Work Order ID: 92682
Parent Item: D120-638-011
Parent Item Name: Bearpaw

Start Date: 11/06/12
Start Qty: 2.00

Required Date: 11/23/12
Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2435 Bearpaw, 206	SMP 2X	Manufactured	No			160	Each	0.0000	2	4	92716		
D2182B050 Clamp Cushion Black	SMP 2X	Manufactured	No			160	Each	5.0000	4	8	86201 JB		

Location	Loc Qty	Loc Code
ST402	1	
79824	1	
ST415	4	
88777	4	

D2274 Radius Block	SMP 2X	Manufactured	No			160	Each	114.0000	8	16	JB		
-----------------------	--------	--------------	----	--	--	-----	------	----------	---	----	----	--	--

Location	Loc Qty	Loc Code
ST008	114	
86855	6	
88452	15	
89280	1	
91919	92	

D2438 Clamp	SMP 2X	Manufactured	No			160	Each	9.0000	4	8	92421 JB 12/12/19		
----------------	--------	--------------	----	--	--	-----	------	--------	---	---	-------------------	--	--

Location	Loc Qty	Loc Code
FG	4	
87532	4	
ST456	5	
77038	5	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

November-07-12 1:53:23 PM

Work Order ID: 92682

Parent Item: D120-638-011

Parent Item Name: Bearpaw

Start Date: 11/06/12

Required Date: 11/23/12

Start Qty: 2.00

Required Qty: 2.00

D2529
Washer

Manufactured No

160 Each 672.0000

16

Location

Loc Qty

Loc Code

ST011

672

79485

16

89356

156

92045

500

89356

AN4-15A
Bolt

Purchased No

160 Each 444.0000

16

Location

Loc Qty

Loc Code

GA

100

120449

100

ST357

327

122800

5

123021

122

123525

200

ST358

17

118706

3

120422

1

122141

13

123900

AN960JD416
Washer

NAS1149D0463J

Purchased No

160 Each 29.0000

16

Location

Loc Qty

Loc Code

ST351

29

116289

8

119097

21

123355

NCR: Yes / No

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Picklist Print

November-07-12 1:53:23 PM

Work Order ID: 92682
 Parent Item: D120-638-011
 Parent Item Name: Bearpaw

Start Date: 11/06/12 Required Date: 11/23/12
 Start Qty: 2.00 Required Qty: 2.00

MS21042L4
 Nut

Purchased No

160 Each 5,216.0000 8

16 JB 12/12/19

Sms 27

Location	Loc Qty	Loc Code
314	244	
122452	244	
ST300	20	
119017	20	
ST314	4952	
123021	2452	123021
123248	900	
123355	1600	

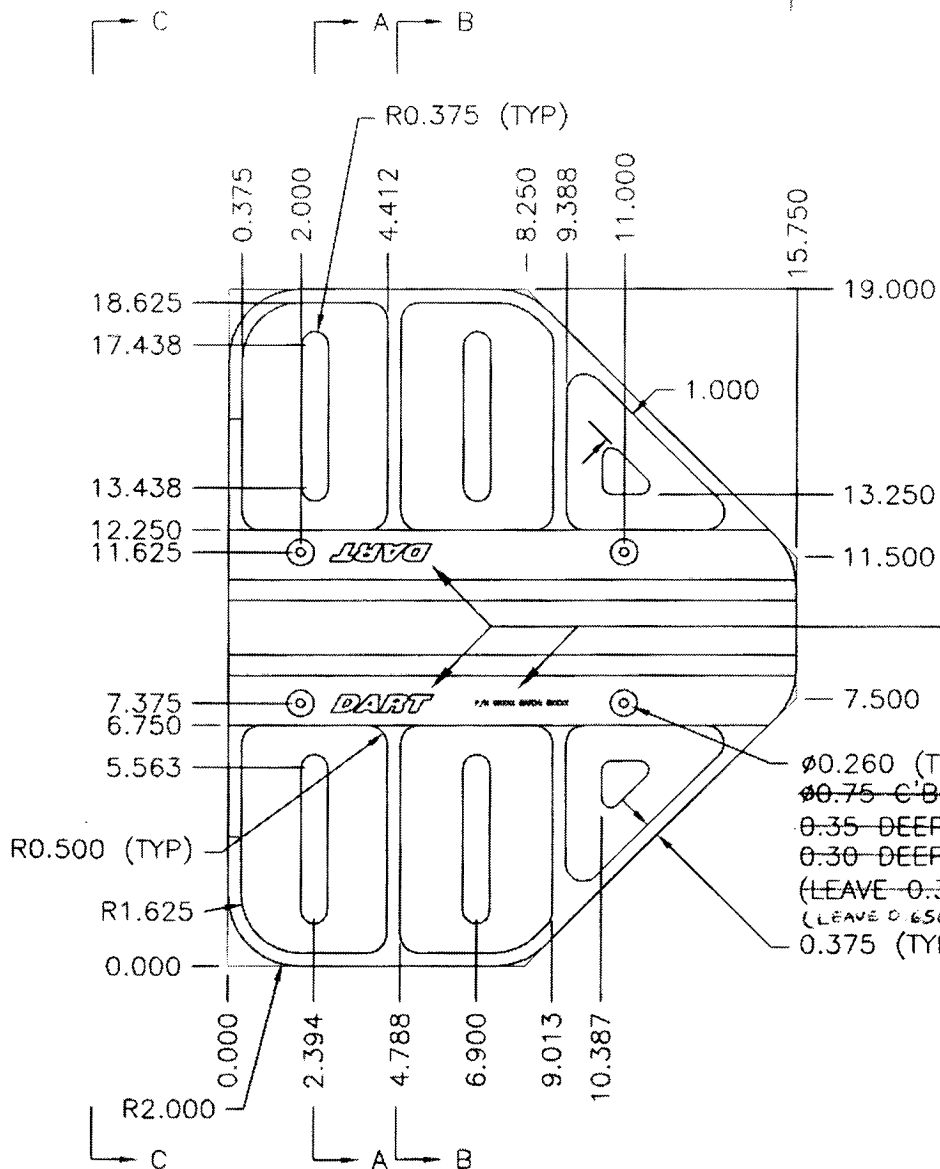
NCR: Yes / No

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ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 $\phi 0.75$ C'BORE 0.30 DEEP FROM BOTTOM
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.)
 (LEAVE 0.650 MIN.)
 0.375 (TYP)

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
KE	KE	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
DATE	DATE	TITLE	SCALE
98.05.19	98.05.19	BEARPAW	1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143

RELEASED
98.06.17 KE

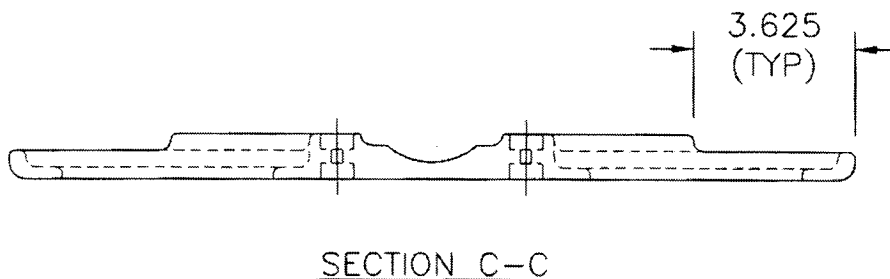
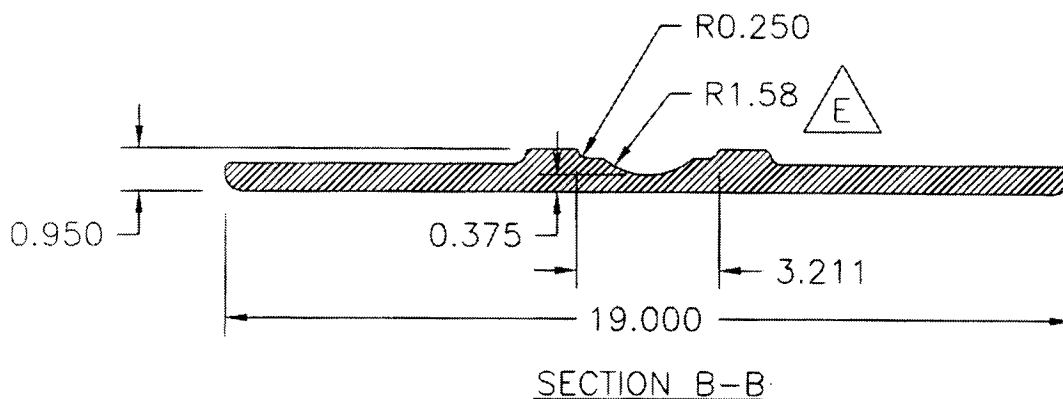
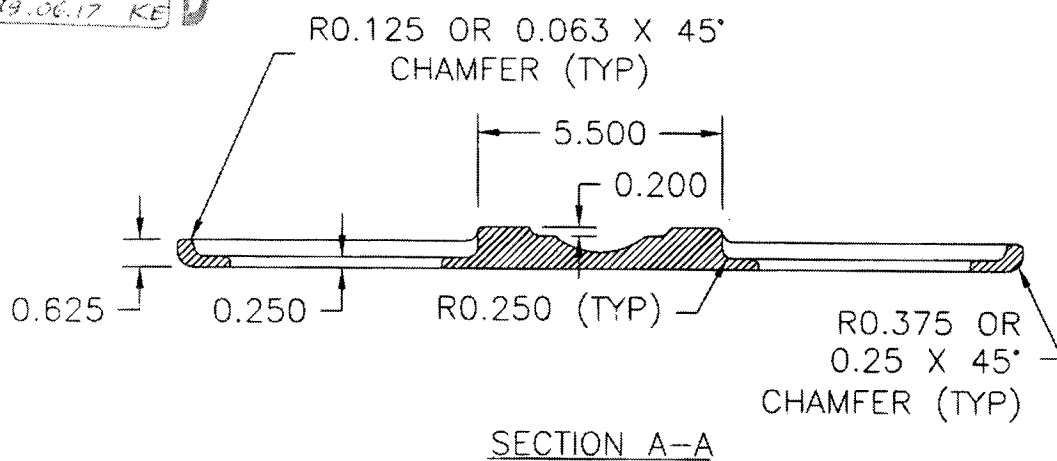
SHOP C
 RETURN
 ENGINEER
 UNCONTROLLED
 SUBJECT TO A
 WITHOUT
 WORK ON
 9.2682
 MJS
 12-11-08





DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED KS	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



92682



REFERENCE ONLY *5m*

IIN-D120-638

Page 4 of 4

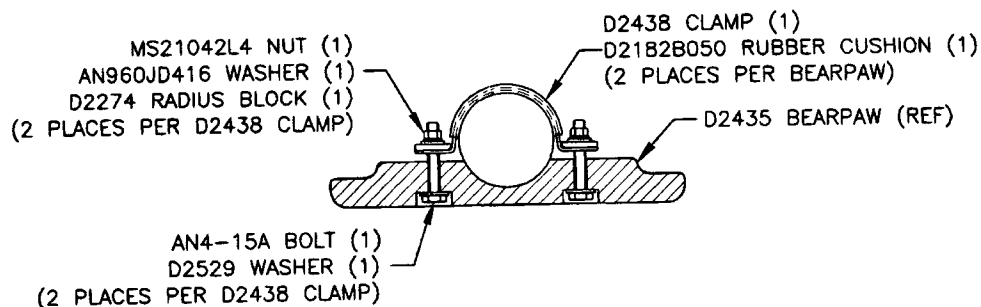


Figure 2 – Bearpaw Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D120-638-011	BEARPAW INSTALLATION
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)

Revision: **A**
Date: 99.07.07